

Date: Thursday, 10/08/2006 9:56:04 AM
 User: Linda.Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR WEDGE	
Job Number	: 28106		Part Number	: D32001	
Estimate Number	: 12110		Drawing Number	: D3200 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/08/2006	S.O. No. : N/A	Drawing Revision	: A	
Prsh't Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 30/08/2006	
Previous Run	: 25633		Qty:	50	Um: Each
Written By	:		Comment	: Est Rev:A Removed from 9 Digit 06-01-25 JLM	
Checked & Approved By	:				

Additional Product

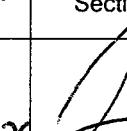
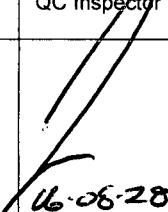
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MUHMWB10	UHMW 1" Black
Comment: Qty.: 0.0525 sf(s)/Unit Total : 1.5750 sf(s) UHMW 1" Black Material: Black UHMW 0.95" or 1.00" thick Use bearpaw scrap material (MUHMWB10) Identify for D3200-1 Batch: <u>M101254</u> En 06/08/25 50		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blank: 2.700" x 2.700 En 06/08/25 50		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3200-1 as per Folio FA337 and Dwg D3200 2-Deburr En 06/08/26 50		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE En 06/08/26 50		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/08/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/06	3	chamfer on bottom side of part is off to one side part was not properly set in the vice		Retake "X" ORIGIN and ENSURE that part is in the RIGHT place SCRAP and Replace	J.G 06/08/06			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:56:04 AM
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Process Sheet

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR WEDGE

Job Number: 28106

Part Number: D32001

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS october 30 50

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST414

10 6/8/30 (50)
LB 06/08/30 (50)

7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(50)
D 06/08/31

Job Completion



C 206/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

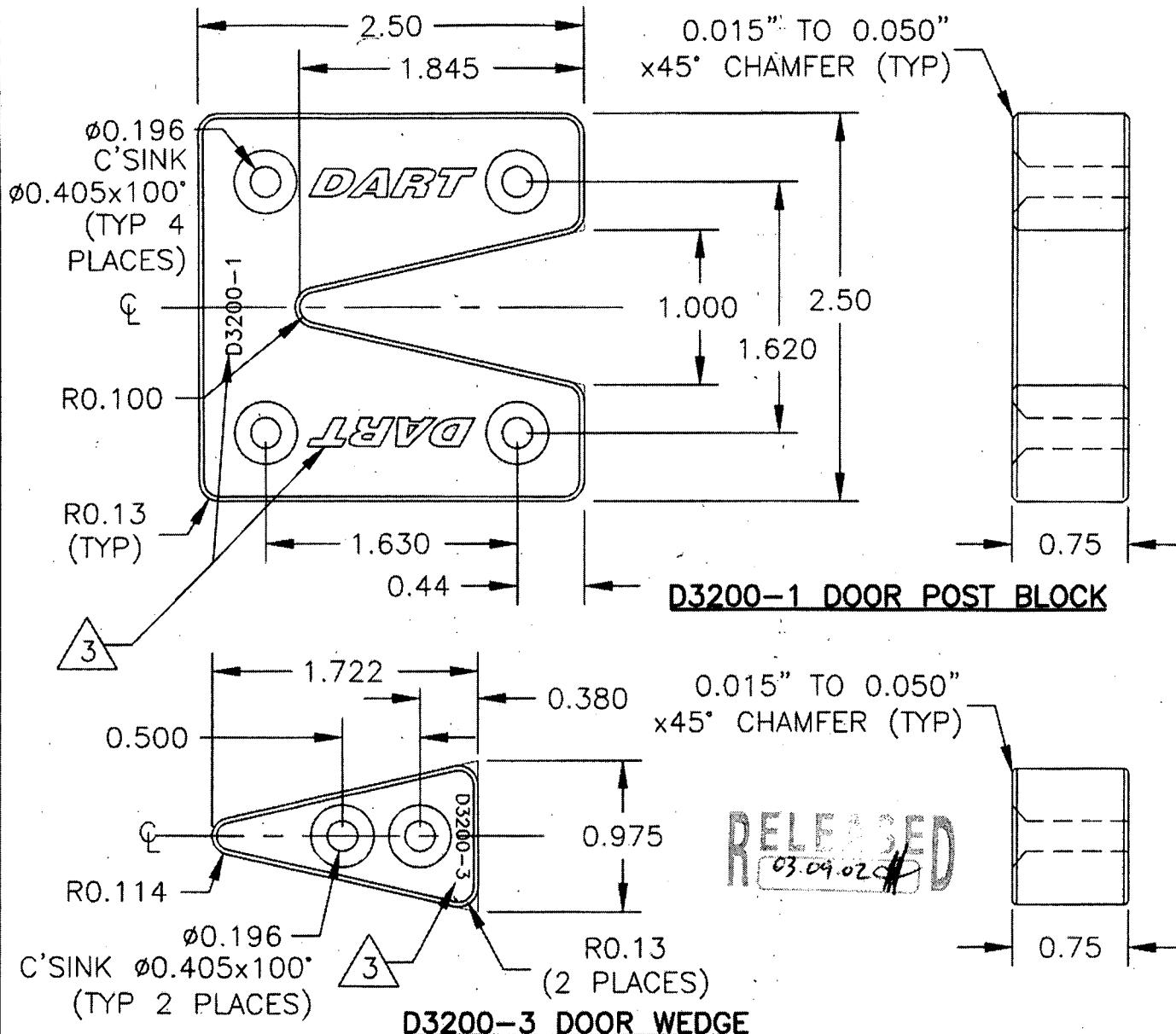
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**COPY ISSUED**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3200	SHEET 1 OF 1
03.08.06		TITLE	SCALE
		DOOR WEDGE	1:1
A	03.08.06	NEW ISSUE	

D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	
Description: Door Post Block	Part Number:	D3200-1
Inspection Dwg: D3200 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	EP	Audited by:	TMF	Prototype Approval:	N/A
Date:	06/08/25	Date:	06/08/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D412-698-015	KJ/RF	

